Work Order ID 98921 Page 1 March-28-13 10:43:07 AM Item ID: D2282-043 Accept *N900040100* Setup Start **Revision ID:** Item Name: Saddle Assembly **Start Qty: 10.00 Start Date:** 3/27/13 **Cust Item ID:** Required Date: 3/27/13 Req'd Qty: 10.00 **Customer:** Reference: Run · Start Process Plan: MLJ Date: 13-14-01 Tooling: Approvals: Date: Date: SPC(Y/N): Date: Tool ID Tool # Plan Reject Sequence ID/ Operation Set Up/ Accept Reject Insp. Work Center ID Description Code Qty Qty Number Stamp **Run Hours Draw Nbr Revision Nbr** D2282 Rev E 100 0.00 13-11-01 MAL 2.0 Large Fab *100* 0.00 Large Fab Memo 1-Weld as per D2282-043 Saddle Assembly Large Fab Filling Rod M125054

Dwg Rev: _______ A/RER316L SS 0.00 110 Small Fab *110* 0.00 Small Fab Memo · 1- Grind weld with rough pad and brown pad, take all welding markes out and Small Fab deburr holes***DO NOT TAKE RED AND BLUE PAD TO BUFF PART*** QC9- Inspect visual per QSI004- Fusion Welds 0.00 120 0.00 QC Memo

Quality Control

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	VFORN	AANCE / UP	PDATE			
											QA Closed:	Date:	
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	L	Cracks			_	Broken/Damaged	\vdash	-1 '	on Incomplete	–	Part Incorre		Weld
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	1	Inspectio	n Strip in	Tube		Cut Too Short		Misread	d .		Power Loss,	'Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Work Ord		921	,	*98	921*						Page 2
Item ID: Revision ID: Item Name:	D2282-043 Saddle Assen	nbly		Accept	*N9(າດດ4	010	ገ*	Setup St	1 \	S1* S2*
Start Date: Required Date: Reference:	3/27/13 : 3/27/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust I	tem ID: ner:					
Approvals:		an:	Date:			Date:				art *N	R1*
Sequence ID/ Work Center I 130 *130* Small Fab Small Fab	D	Operation Description - Memo 1 -Tumble		Set Up/ Run Hours 0.00	Tool	ID Too	l# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control		QC5- Inspect part comple Memo	teness to step on W/O	0.00	27 9-89][X)			· · · · · · · · · · · · · · · · · · ·
*160 *160* Packaging Packaging		Identify as per dwg & Sto Memo	ck Location 1	0.00				Jo			13/u/n

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NCR	No.					Work Order Update	1	1	Large Fab	Comp			Supplier	1 1
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1	1	inspection	n Strip in	Tube		Cut Too Short	1	Misread	t			Power Loss/	'Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord March-28-13	der ID 98 10:43:07 AM	921		*989	721*						Pa	ge 3
Item ID: Revision ID: Item Name:	D2282-043 Saddle Assem			Accept	*N900	040	100)*	Setup	Start Stop	14.71	
Start Date: Required Dat Reference:	3/27/13 e: 3/27/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item II Customer:	D:						
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ıte:	_		Run	Start	*NR1	*
	QC:		Date:	SPC (Y/N):	Da	te:				Stop	*NR2	*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Insp. Number , Stam	
170 QC		QC21- Final Inspection -	Work Order Release	0.00	·					13	111/189	4
Quality Control		Memo		0.00							MK 12	11-15

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Work Orde	r·				DISPOSITION			· · · · · · · · · · · · · · · · · · ·	AGAINST DEI		PROCESS	
Part N	o		***************************************		Rework Scrap Use-as-is Work Order Update		Therm	Machining S	Crosstube Small Fab Finishing omposite	ľ	Water Jet J. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
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[Inspect	ion Strip ir	1 Tube		Cut Too Short		Misread	d		Power Loss/S	Surge	Other
	Ripples	in Bend			Drill Holes		Offset				17.5	
	Torque	Waves in	Extrusio	n	Drawing		Out of (Calibration			· · · ·	
	Turning	Sequence	<u> </u>		Finish		Out of S	Sequence				
	Wave/	wist in Tu	be		Folio		Outside	Dimensions				

Picklist Print

March-28-13 10:43:07 AM

Page 1

Work Order ID:

98921

Parent Item:

D2282-043

Parent Item Name:

Saddle Assembly

Start Date: 3/27/13

Required Date: 3/27/13

Start Qty: 10.00

Required Qty: 10.00

Comments:	IPP Rev:A	Removed from 9 Di	git 0	05-12-02 JLN	1								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2281 Jack Saddle		Manufactured	No			100	Each	26.0000	1	10			
3108	575 X 2	[0]		Location WA001 675.		<u>Loc Qtv</u> 26 17 9		oc Code		<u>20</u>	13-	-11-0	1 ma
D2282-7 Tube		Manufactured	No			100	Each	55.0000	2	20			
B 1081	630 × 9	90-7		Location WA001 800 933		Loc Oty 55 5 50		oc Code		40	13-	11-0	" MA

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	_					Rework			Skid-tube	Crosstube	\neg		Water Jet		Engineering
Part N	ο.					Scrap		ſ	Machining	Small Fab		Proc	d. Eng. Coor.		Quality
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Ţ	7	Turning Se	equence			Finish		Out of	Sequence		_				

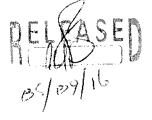
Outside Dimensions

Wave/Twist in Tube

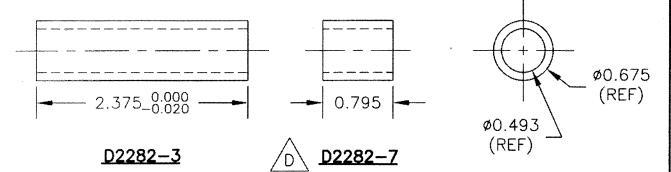
Folio



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CHECH	(ED . O	APPROYED	DRAWING NO. REV. E
	W	1000	D2282 SHEET 1 OF 2
DATE			TITLE SCALE
 05.0	6.07		HANDLE TUBES 1:1
Α		94.10.14	NEW ISSUE

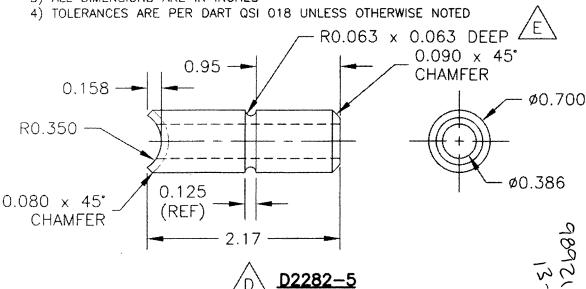


05.0	06.07	HANDLE TUBES 1:
A	94.10.14	NEW ISSUE
В	95.03.23	RE-DESIGN
С	97.10.20	CORRECTED NUMBERING SCHEME
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES



D2282-5 STEM:

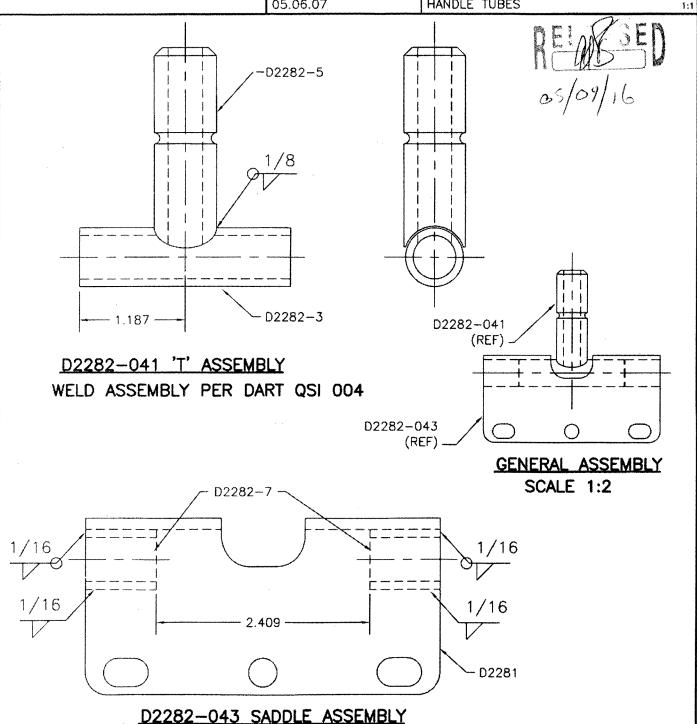
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN BW	DRAWN BY	DART AEROS HAWKESBURY, ONT.	
CHECKED	APPROVED	DRAWING NO.	REV. E.
U'	1 1115	D2282	SHEET 2 OF 2
DATE		TITLE	SCALE
05.06.07	·	HANDLE TUBES	1:1



WELD ASSEMBLY PER DART QSI 004

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